

# Work Order ID 63088



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October 20, 2010 3:11:06 PM

Item ID: D3890-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 10/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten initials*

Date: 10/10/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3890	A								

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3890

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

0.00

*B10-10-21*

*(Handwritten mark)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*B10-10-21*

**Work Order ID 63088**

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October 20, 2010 3:11:06 PM

Item ID: D3890-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 10/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> <u>B 63084</u>  Memo	0.00  0.00		<u>83</u>	<u>10/20/21</u>	<u>(4)</u>			
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>10/20/21</u> <u>MF</u> <u>10-10-21</u>

# Picklist Print

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Page 1

Work Order ID: 63088

Parent Item: D3890-3

Parent Item Name: Gasket



Start Date: 10/20/10

Required Date: 10/21/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	784.7000	0.026	0.054737			



4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"



B10-0-01

Location

Loc Qty

Loc Code

MAT

500

114937

500

MAT052

284.7

112335

284.7

112335

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

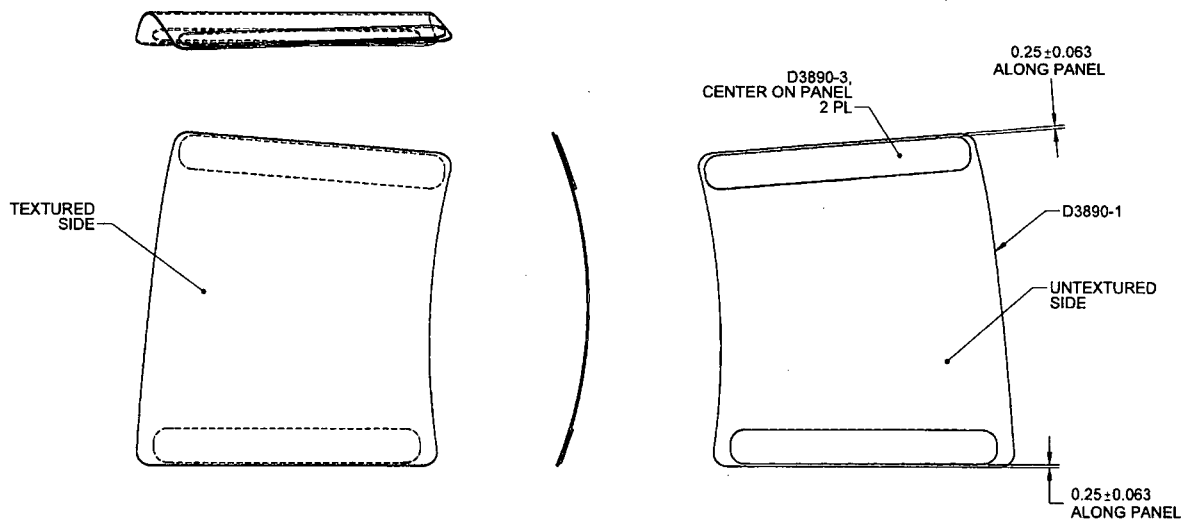
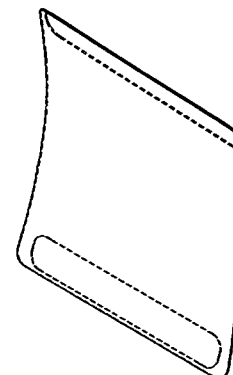
**NOTE:** Date & initial all entries



**PARTS LIST**

ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43088  
PHO-10-20



**D3890-041 PANEL, SIDE**

**RELEASED**  
9/15/13

**NOTES:**

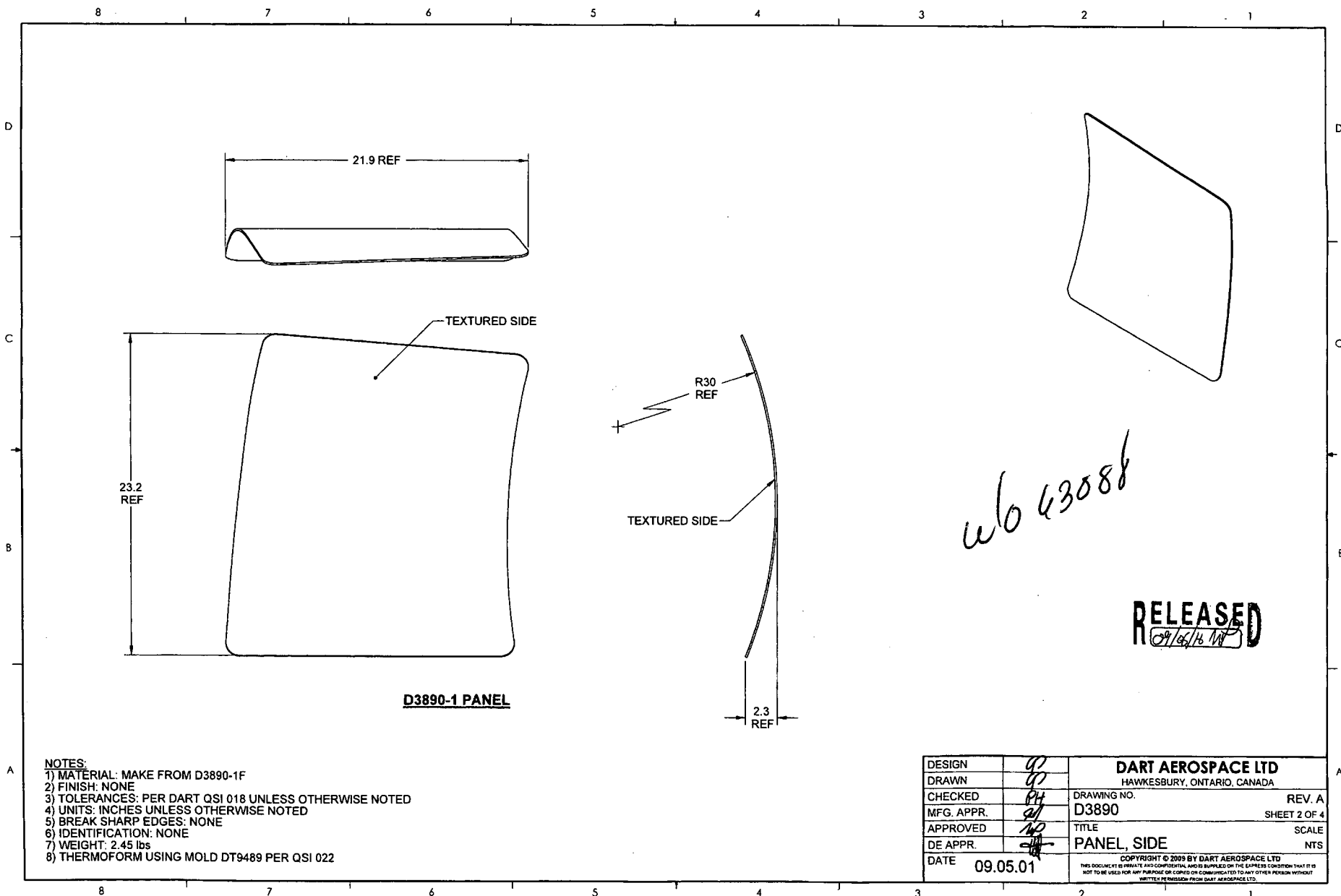
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

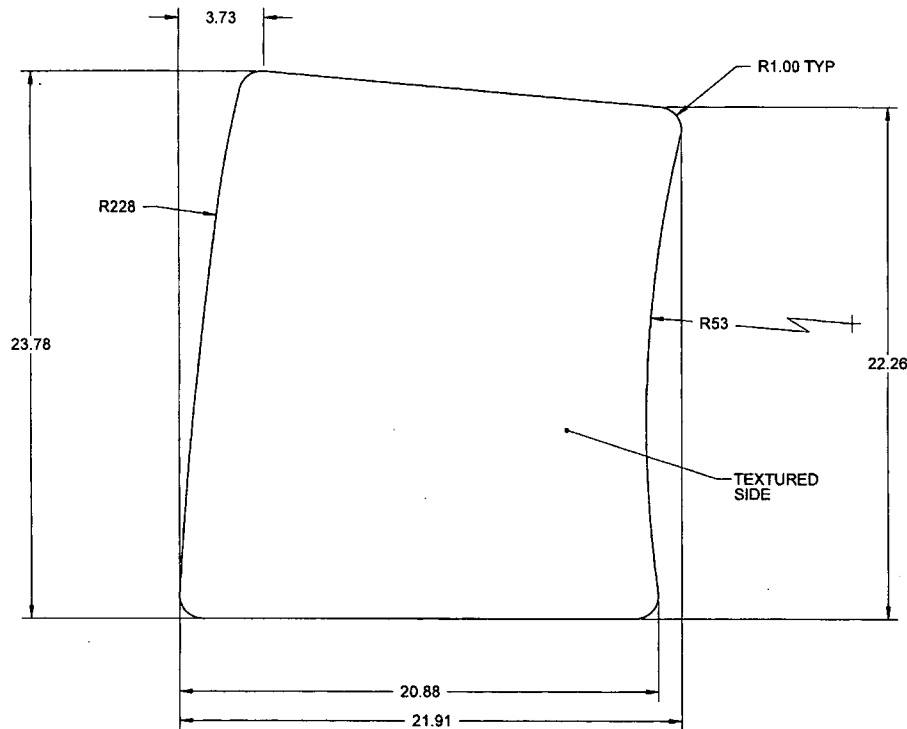
REV.	NEW ISSUE	DESCRIPTION	CP	09.05.01
DESIGN	90		BY	DATE
DRAWN	90			
CHECKED	PH			
MFG. APPR.	21			
APPROVED	29			
DE APPR.	21			
DATE	09.05.01			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3890  
REV. A  
SHEET 1 OF 4  
TITLE PANEL, SIDE  
SCALE NTS

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**D3890-1F PANEL**

*u1063085*

**RELEASED**  
*CP/66/16 M*

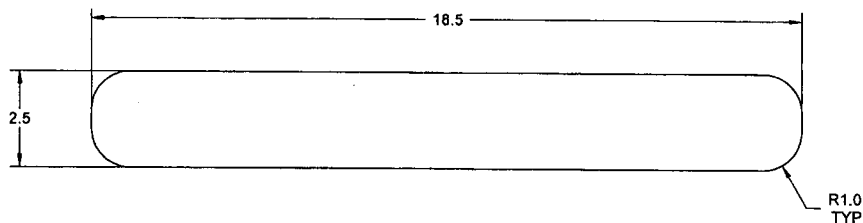
**NOTES:**

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

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CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>21</i>	<b>D3890</b>	SHEET 3 OF 4
APPROVED	<i>22</i>	TITLE	SCALE
DE APPR.	<i>22</i>	<b>PANEL, SIDE</b>	NTS
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0.125  
REF



**D3890-3 GASKET**

*wb63088*

**RELEASED**  
*9/16/14 M*

**NOTES:**

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>21</i>	<b>D3890</b>	SHEET 4 OF 4
APPROVED	<i>12</i>	TITLE	SCALE
DE APPR.	<i>11</i>	<b>PANEL, SIDE</b>	NTS
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